

Tool working Pipe

A20-200

The tool is produced by a solid cylinder with conventional wheels. It allows to change the spline geometry fast and economically by simply changing the wheel-DXF and redress the new geometry on the same wheel, and for small splines the wheel can be kept sharp as being redressed when needed.



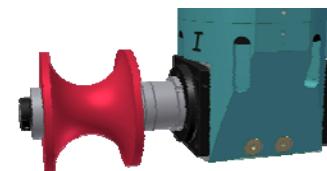
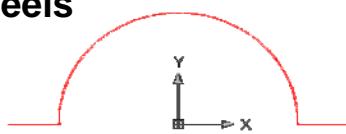
1. Cycletime for Production

Tool specifications	
Diameter 139 mm, Z26, Length of cutting edge 90mm, depth tooth: 5.3mm, Material 18NiCrMo7-6+HH	
Operations	
Feed [mm/Min]	120
Power [kW]	1
Cutting feed [m/s]	32
Used wheels	1
Grinding time [s]	120
Total cycle time	1440
26 Min 00	

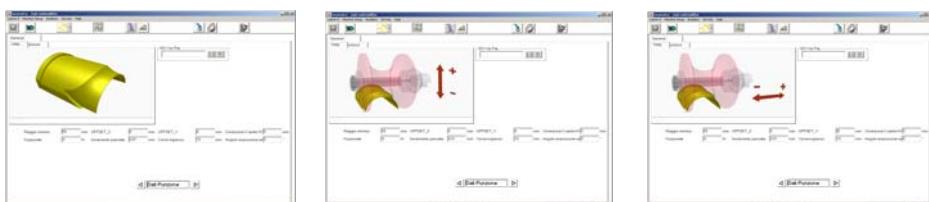
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø125 DXF Conventional



3. Machine and Software Requirements



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Machines: 5 axes CNC grinders : NORMA CFG
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5, DXQ
Engineer: Diego Albiero, 01.04.2009

